

Date: Friday, 22/08/2008 10:03:54 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 41590	
Estimate Number : 10534	
P.O. Number :	Part Number : D2574
This Issue : 22/08/2008 S.O. No. :	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 40517	Material :
Written By :	Due Date : 12/09/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 08.8.22</u>	
Comment : Est Rev: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: 34874

JS 08/09/12 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 41590 Double check by: ml

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

ml / JS 08/09/12 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

ml / JS 08/09/12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml / JS 08/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 10:03:54 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 41590

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/09/16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M- 08/09/17

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:30pm

M 08-09-17 (X10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 8/9/18 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

sty33

P 8/9/18 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



u 08/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41590
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.749	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.006	7.999	8.000		
F	0.490	0.510		.500	.501	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.506	.499	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.574	.567	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.368	1.371	1.368	1.369		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	4.119	4.129		4.120	4.122	4.123	4.123		
P	0.115	0.135		.120	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.243	.253	.252	.252		
S	0.115	0.135		.119	.120	.121	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		.233	.241	.240	.241		
W	0.115	0.135		.118	.131	.126	.127		
X	0.307	0.312		.311	.310	.311	.312		
Y	0.760	0.765		.761	.760	.761	.761		
Z	0.352	0.372		.369	.376	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.629	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.248	.252		
AE	1.500	1.520		1.510	1.512	1.512	1.511		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.240	.265	.265	.265		
AH	0.240	0.260		.244	.249	.249	.257		
AI	2.000	2.020		2.002	2.004	2.005	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	aml
Date:	08/04/15

Audited by:	JL
Date:	08/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 41590
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.500	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.500	.499	.499		
J	1.174	1.184		1.180	1.180	1.179	1.179		
K	0.558	0.578		.567	.567	.568	.566		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.365	1.375		1.368	1.370	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.499	2.499		
O	4.119	4.129		4.121	4.123	4.122	4.123		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.128	.127	.130	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.242	.241	.241		
W	0.115	0.135		.128	.128	.129	.129		
X	0.307	0.312		.310	.310	.311	.311		
Y	0.760	0.765		.766	.766	.760	.760		
Z	0.352	0.372		.366	.366	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.254	.246	.249		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.260	.266		
AH	0.240	0.260		.250	.257	.257	.257		
AI	2.000	2.020		2.003	2.003	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>aml</i>	Audited by: <i>J.L</i>
Date: 08/09/15	Date: 08/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
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DART AEROSPACE LTD		Work Order: 41590
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	29	210	3	4		
A	0.438	0.443		.441	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.501	.499				
G	0.257	0.262		.260	.258				
H	0.375	0.380		.377	.376				
I	0.490	0.510		.499	.501				
J	1.174	1.184		1.180	1.180				
K	0.558	0.578		.565	.565				
L	1.174	1.184		1.180	1.180				
M	1.365	1.375		1.371	1.371				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.122	4.122				
P	0.115	0.135		.127	.126				
Q	0.115	0.135		.135	.130				
R	0.240	0.260		.252	.250				
S	0.115	0.135		.126	.127				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.236	3.233				
V	0.230	0.250		.241	.242				
W	0.115	0.135		.121	.121				
X	0.307	0.312		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.249	.250				
AE	1.500	1.520		1.516	1.510				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.251	.251				
AI	2.000	2.020		2.003	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>ML 128</i>
Date: 08/09/16

Audited by: <i>JL</i>
Date: 08/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

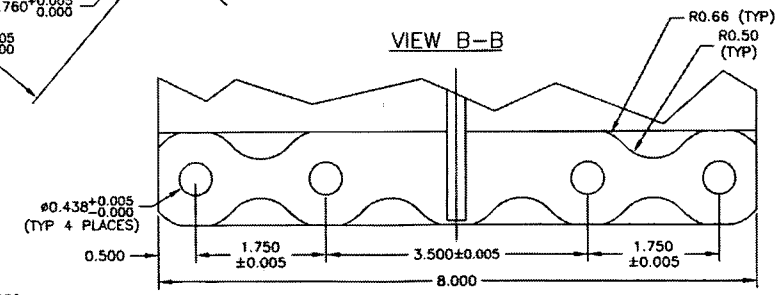
RELEASED
05.12.06

NOTES

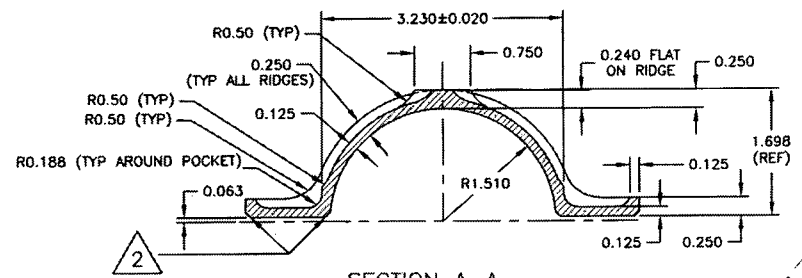
MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

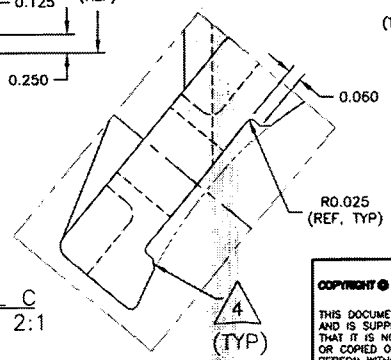
VIEW B-B



SECTION A-A



DETAIL C SCALE 2:1



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	05.07.13	TITLE INNER AFT SADDLE
DRAWING NO.	D2574	REV. E
SHEET	1 OF 1	SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 11590